

Work Order ID 67838

Thursday, March 31, 2011 3:33:50 PM



Page 1

Item ID: D3806-5

Accept



Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 3/31/2011 Start Qty: -6.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *MF* Date: *11-03-31*

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3806	Rev A
-------	-------

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3806

Dwg Rev:

Prog Rev:

2-Deburr if necessary

Manual Mill

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

11/04/06

11/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D3806-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 3/31/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/4/12

6

150

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

0.00

Packaging

EL 11-4-12 X6

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/12

11-04-12

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Picklist Print

Thursday, March 31, 2011 3:33:44 PM

Page 1

Work Order ID: 67838

Parent Item: D3806-5

Parent Item Name: Bar



Start Date: 3/31/2011

Required Date: 4/7/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
IPP Rev:B 08-09-23 redesign DD verified by:EC
IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased	No			100	f	22.0000	0.93	5.873684			

304 BAR .500 x 2.50

Location	Loc Qty	Loc Code
MAT050	22	
112764	16	
F16135	6	

M304 B0.500 X .250

M117176

22.5 f.

11/04/06

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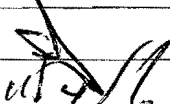
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 67838
Description: BAR		Part Number: D3806-5
Inspection Dwg: 3806 , Rev: A		Page 1 of 1

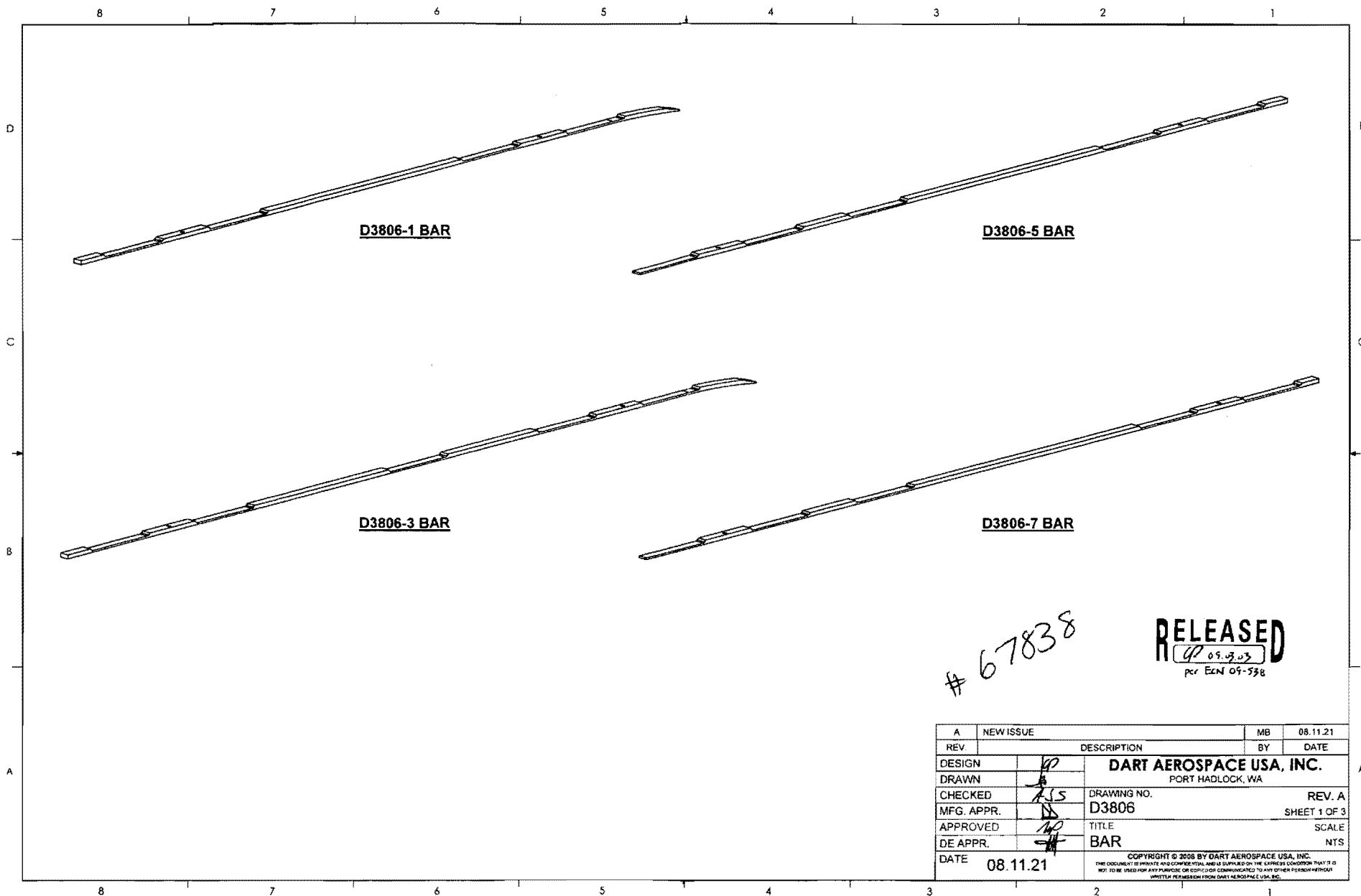
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	$\pm .030$	4.010	✓		RA21	TAPE
7.00	$\pm .030$	7.030	✓		RA21	"
4.00	$\pm .030$	4.010	—		RA21	"
14.00	$\pm .030$	14.05		✓		} ACCEPTABLE DEVIATION 11.04.06
31.00	$\pm .030$	31.05		✓		
38.00	$\pm .030$	38.05		✓		
43.50	$\pm .030$	43.52	—		RA21	
.500	.500	.502	—		RA26	vern
.250	.250	.255	—		"	"
.130	.130	.132	—		"	"

Measured by: 	Audited by: 	Prototype Approval:
Date: 11/04/06	Date: 11/04/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



67838

RELEASED
 09-09-03
 per EEN 09-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	LP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3806	SHEET 1 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BAR	NTS
DATE	08.11.21	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Dart Aerospace Ltd

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8 7 6 5 4 3 2 1

D

D

C

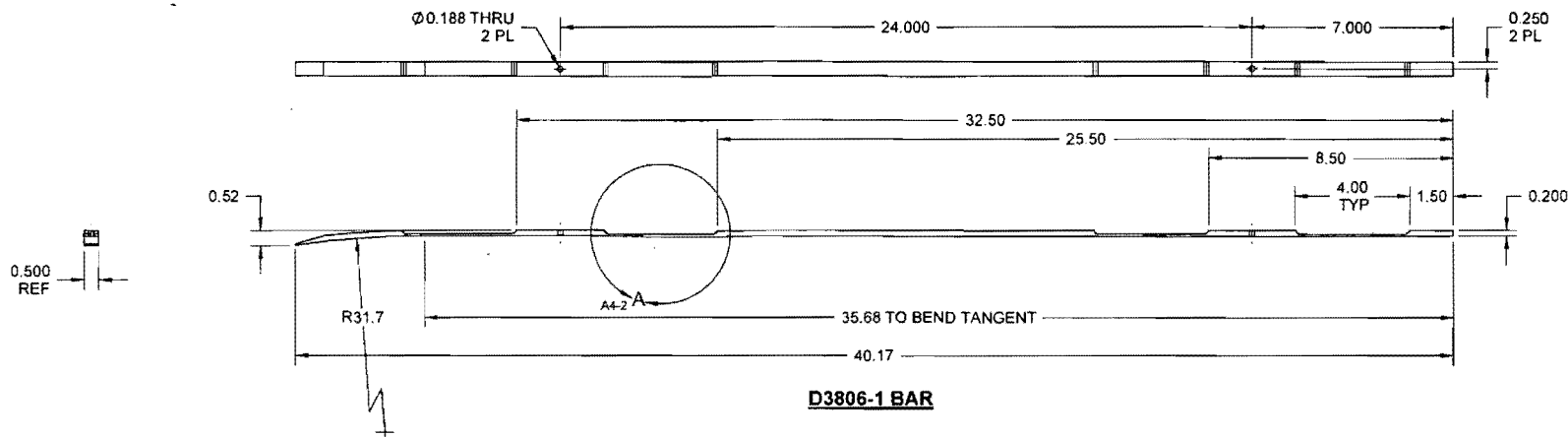
C

B

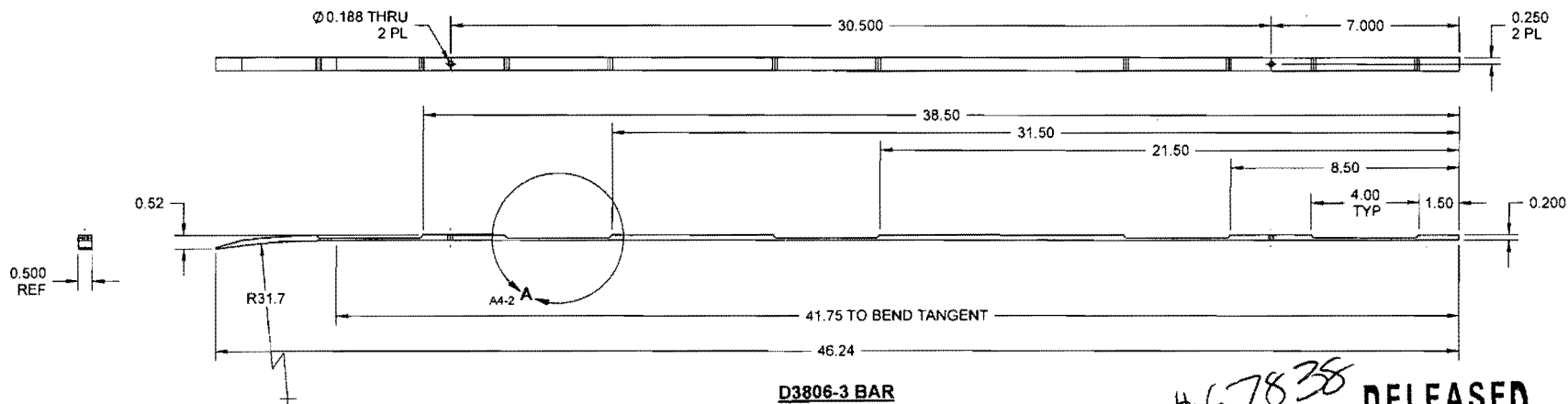
B

A

A



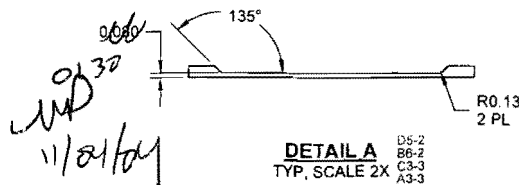
D3806-1 BAR



D3806-3 BAR

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-1 = 0.87 lbs
D3806-3 = 0.98 lbs



DETAIL A
TYP, SCALE 2X

#67838
RELEASED
01/04/03

DESIGN	JP	DART AEROSPACE USA, INC.	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3806	SHEET 2 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BAR	NTS
DATE	08.11.21	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

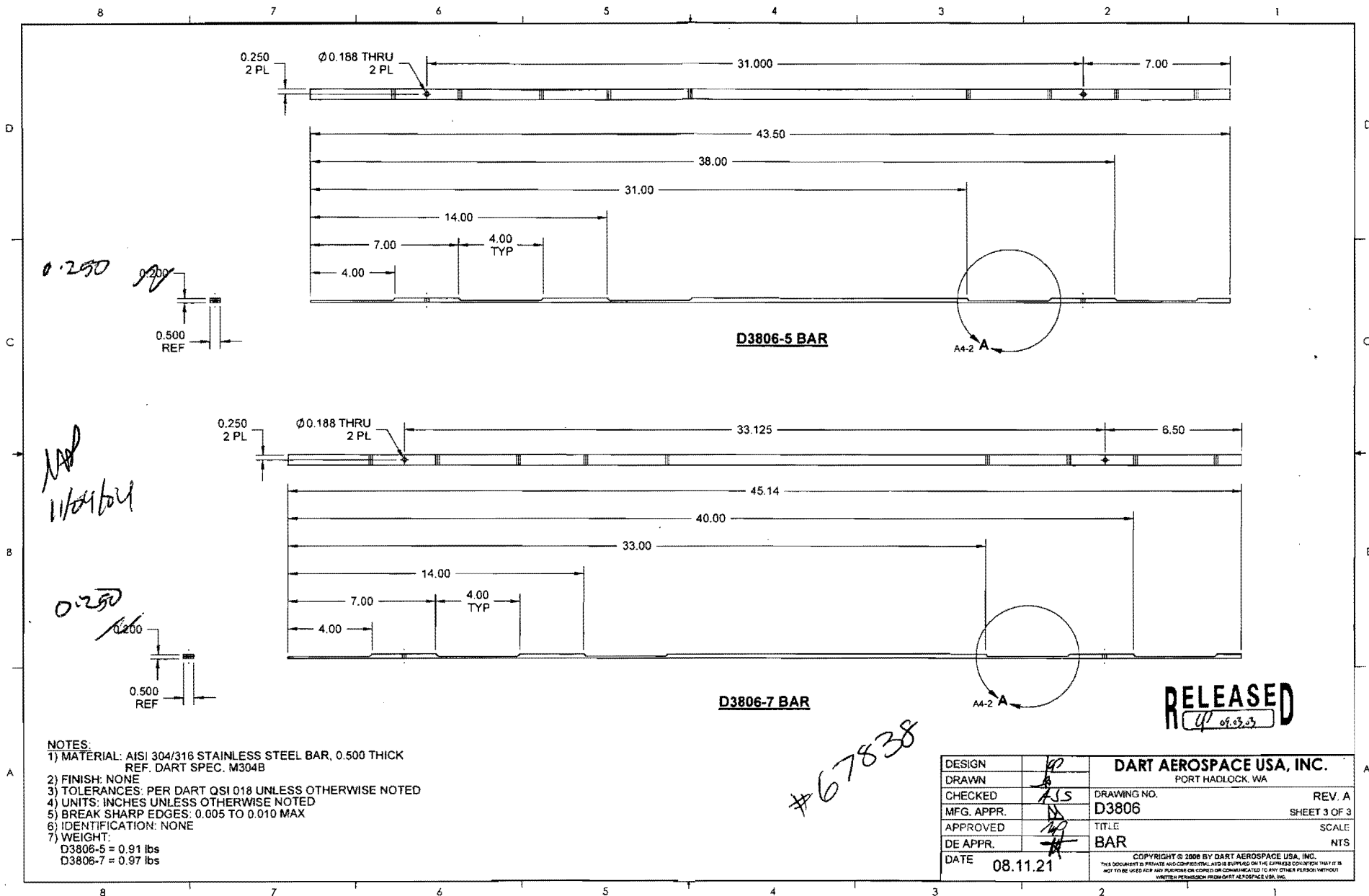
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